

Work Order ID 50488

July 10, 2009 2:38:53 PM

Page 1

Item ID: D3844-1KIV

Accept

Revision ID: A-Proto

Item Name: Overhead Panel, LH

Start Date: 07/13/2009 Start Qty: 1.00

Required Date: 07/17/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: ME

Date: 09-07-10 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3844

Rev PROTO 09-07-08

100



Hand thermo

Hand Finishing Thermoforming

Rev A 09-06-18 approved.

0.00

Memo

1-Cut Sheet to required Blank size

0.00

BB 09/07/13 (X1)
M109703

110



Thermoform

Thermoforming Machine

0.00

Memo

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA048 using tool DT9290-B
Dwg Rev:
Folio Rev:

0.00

BB 09/07/13 (X1)

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Item ID: D3844-1KIV

Accept



Setup Start



Revision ID: A-Proto

Stop



Item Name: Overhead Panel, LH

Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

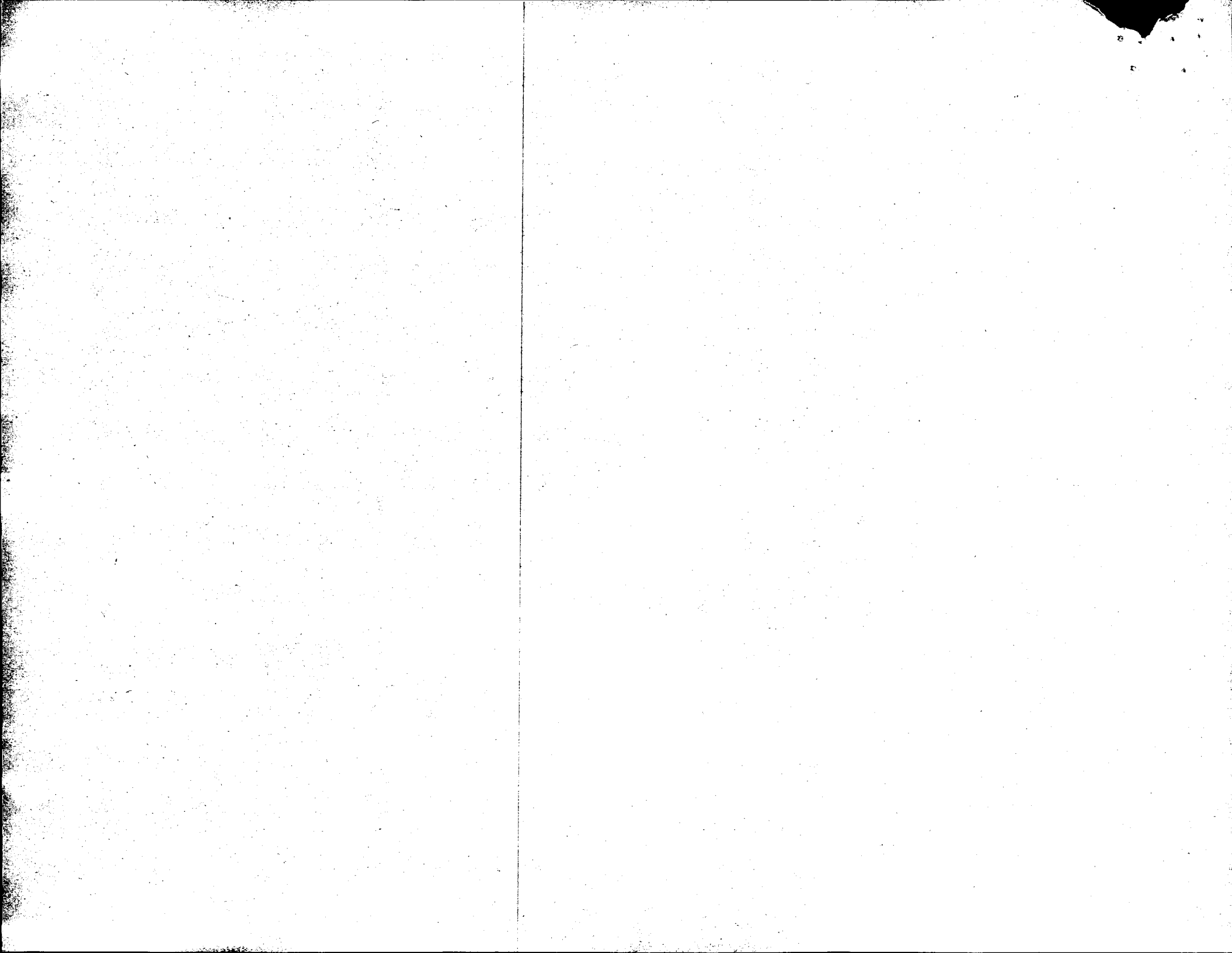


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control	Visually inspect part for proper formation and texture								
130	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									
140		0.00							
Hand Thermo	Memo	0.00							
Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg								

BB 09/07/16 (X1)

Wh. 09/07/14 (X1)

Wh. 09/07/14 (X1)



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Item ID: D3844-1KIV
Revision ID: A-Proto
Item Name: Overhead Panel, LH

Accept



Setup Start



Stop



Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



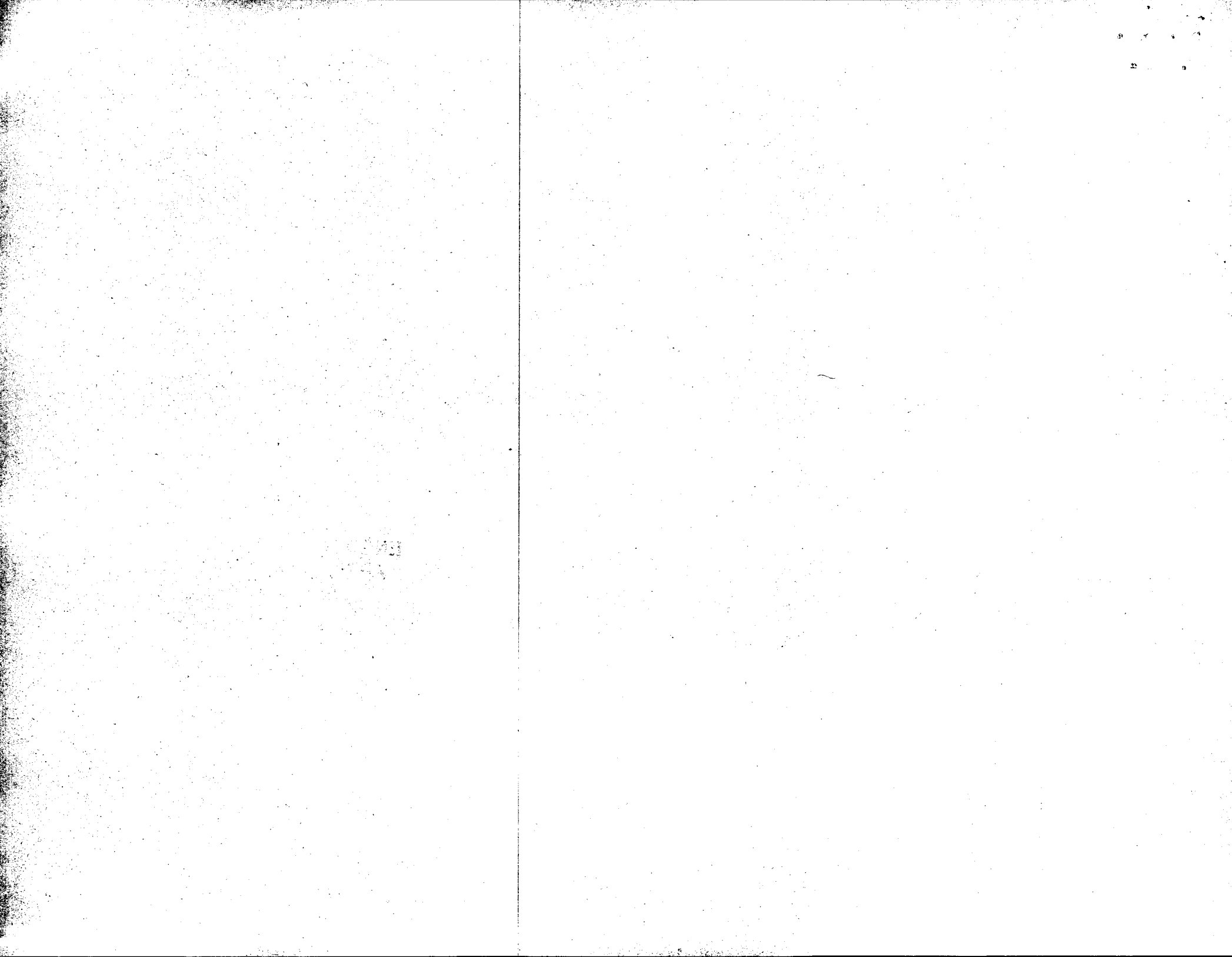
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control	Complete FAI document								
160	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							
Packaging									

Dh 09/07/14 (X)

PA 09-07-20

ENGINEERING
APPROVAL

FOR ENG'G
TEST
PA 09-07-20



Work Order ID 50488

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Item ID: D3844-1KIV
Revision ID: A-Proto
Item Name: Overhead Panel, LH

Accept



Setup Start



Stop



Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

09.07.20 PROTOTYPE

24-07-09
WF 09-07-24

Picklist Print

Page 1

July 10, 2009 2:38:53 PM

Work Order ID: 50488

Parent Item: D3844-1KIVRevA-Proto

Parent Item Name: Overhead Panel, LH

Comments:

Start Date: 07/13/2009

Required Date: 07/17/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	894.5038	5.8819			



6185 KYDEX .080"



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

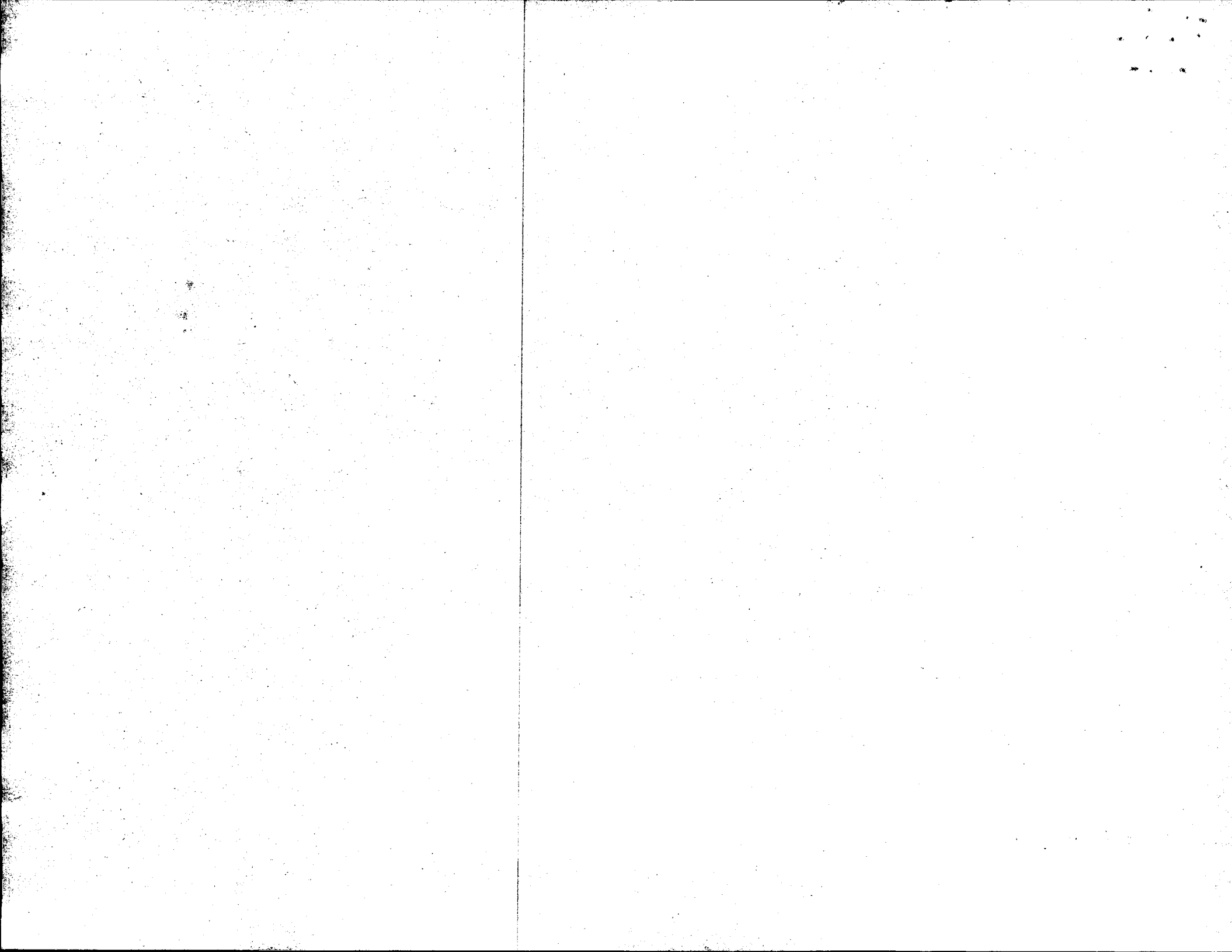
MAT

894.5037653

109703

894.503765

BB 07/07/13 (X1)
M109703



DART AEROSPACE LTD	Work Order: 50488
Description:	Part Number: 03844-1K10
Inspection Dwg: 03844 Rev: A PROTO.	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BD

Date: 09/07/16

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
25.4"	± .100	.5"	✓			
25.5" 36.74	Ref.	25.5"	✓			
3.1"	Ref.	3.1"	✓			
12.3"	Ref.	12.5"	✓			
.3"	± .100	.375	✓			
0.045 0.050	MIN	0.037	✓			
0.045 0.050	↓	0.05	✓			
0.050 0.050 35	↓	0.040	✓			

Measured by: W. Hagen

Date: 09/07/14

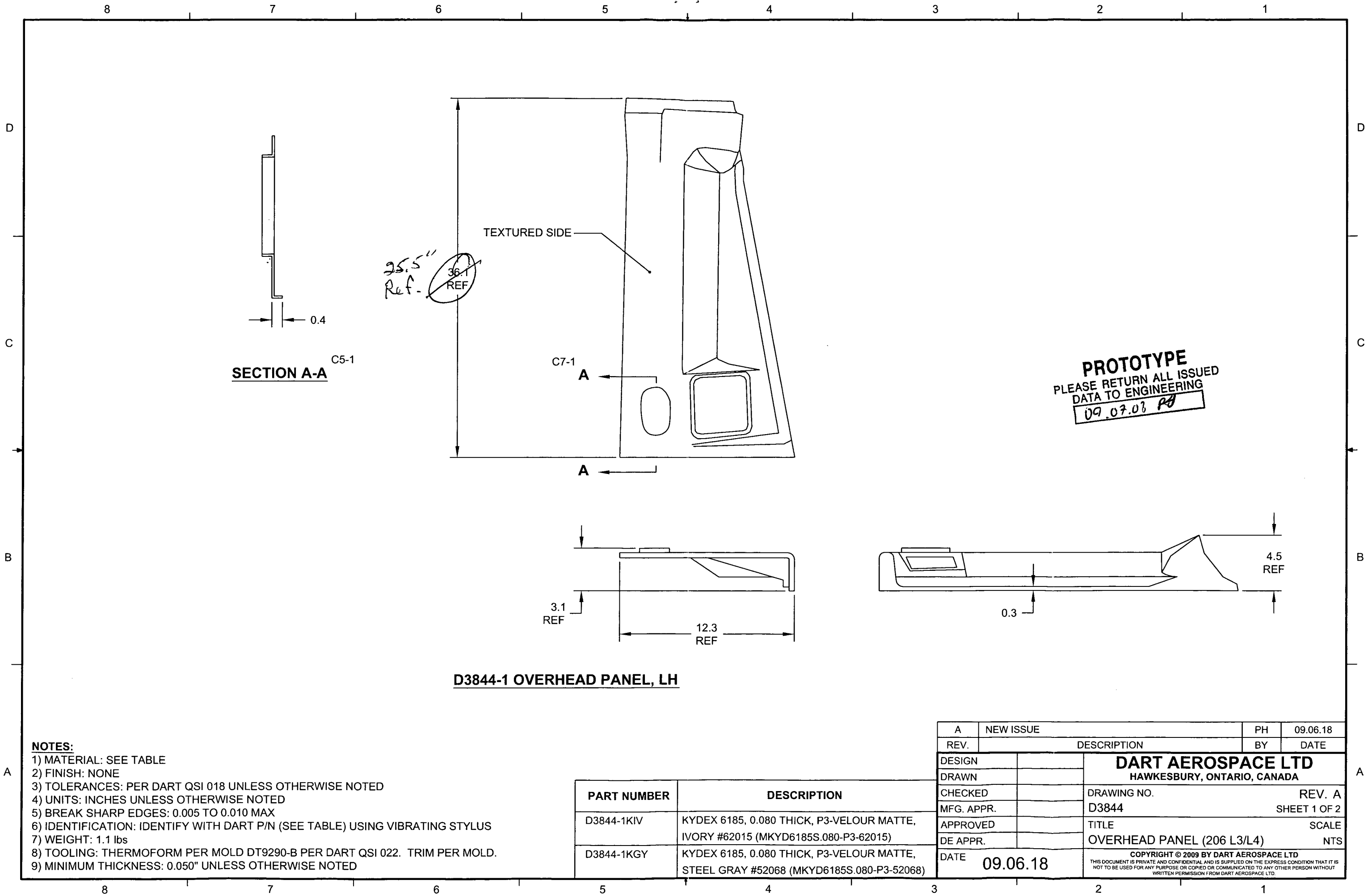
Audited by: PH

Date: 09.07.12

Prototype Approval: PH

Date: 09.07.17

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



PART NUMBER	DESCRIPTION
D3844-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3844-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

A	NEW ISSUE	PH	09.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3844	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		OVERHEAD PANEL (206 L3/L4)	NTS
DATE	09.06.18	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

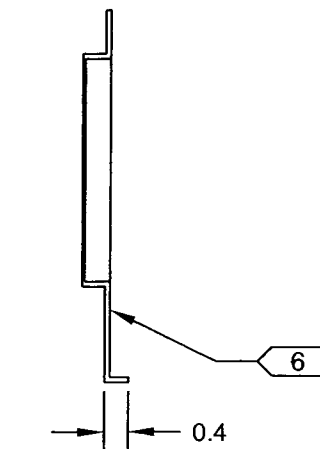
- NOTES:**
- 1) MATERIAL: SEE TABLE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
 - 7) WEIGHT: 1.1 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9290-B PER DART QSI 022. TRIM PER MOLD.
 - 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

D

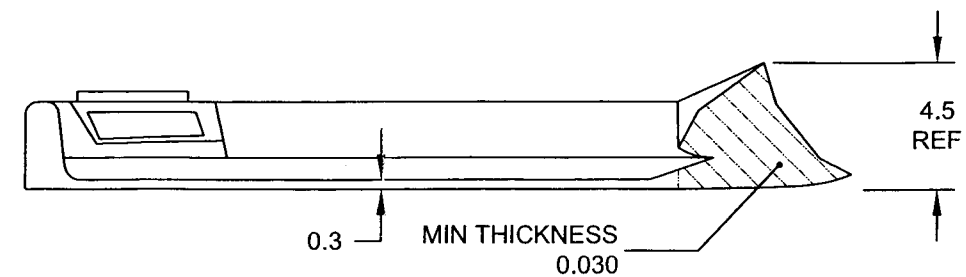
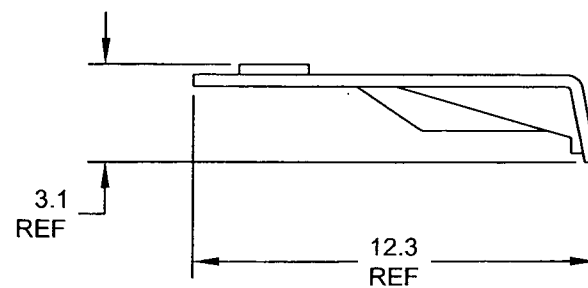
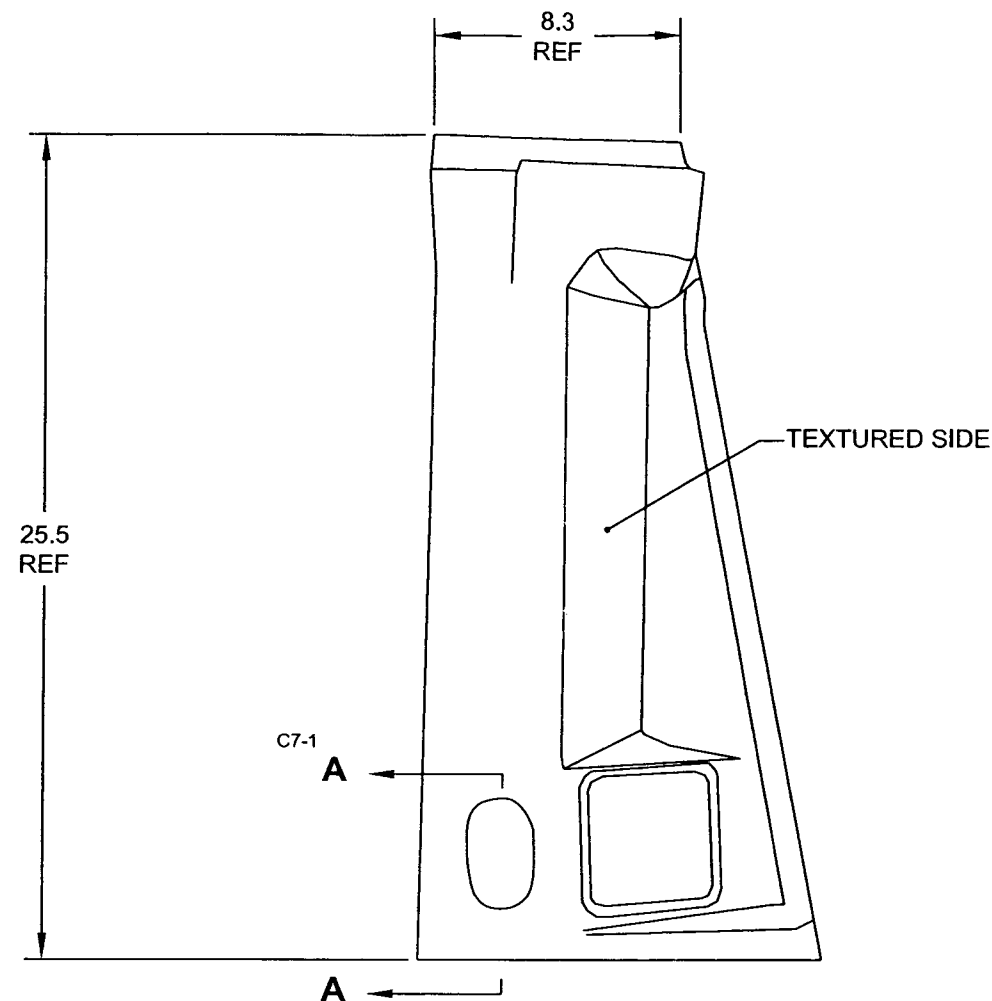
C

B

A



SECTION A-A C5-1



D3844-1 OVERHEAD PANEL, LH

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.1 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9290-B PER DART QSI 022. TRIM PER MOLD.
- 9) MINIMUM THICKNESS: 0.045" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3844-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3844-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

A	NEW ISSUE	PH	09.06.18
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